



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4681-041
Job Sheet 179497



Part No: D4681-041

Job Qty: 8 ea

Part Name: Web Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/19/18

Job Tracking No:

Due Date: 7/2/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV B SHEETS 1,2 IPP REV:A 13.04.15 NEW ISSUE DD VERF:JLM IPP REV:B 13.08.08 PB1 DD VERF:JLM IPP REV:C 13.11.14 AS PER DWG REV,B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea	7/2/18	7/2/18	0.00	0.00	Start Up Skid tubes-2		DD
110	Skid tubes	8 pcs	7/2/18	7/2/18	0.00	6.90	Skid tubes-2		DD DAS 38
120	QC	8 pcs	7/2/18	7/2/18	0.00	0.00	QC6		38
121	CNC Vertical Machining	8 pcs	7/2/18	7/2/18	0.18	5.26	HAAS1-5		18/07/16
122	QC	8 pcs	7/2/18	7/2/18	0.00	0.00	QC2 Machining-3	SBL	18/07/16
123	QC	8 pcs	7/2/18	7/2/18	0.00	0.00	QC8 Machining-3		18/07/17
130	HandFinish	8 pcs	7/2/18	7/2/18	0.00	2.23	HandFinish1		18/07/17
140	QC	8 pcs	7/2/18	7/2/18	0.00	0.00	QC7-4		18/07/17
150	Skid tubes	8 pcs	7/2/18	7/2/18	0.00	6.90	Skid tubes-3		18/07/17
160	QC	8 pcs	7/2/18	7/2/18	0.00	0.00	QC5		18/07/17
170	Packaging	8 pcs	7/2/18	7/2/18	0.00	0.00	Packaging3-2		18/07/17
180	QC21-SA	8 Ea	7/2/18	7/2/18	0.00	0.00	QC21		DAS 21 JUL 23 2018

Part Op 110 - 1- CUT TO LENGHT AS PER DWG

Descriptions: 121 - MILL AS PER DWG AND FOLIO FB186 DWG REV: _____ FOLIO REV: _____
150 - INSTALL DOUBLER BY REVITING AND SEALING FAYING SURFACE WITH PROSEAL AS PER DWG A/R
PROSEAL: 138848

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2963-125	105 I-Beam Extrusion	8 Ea (1 ea)	90-Start up Operation	B156372
D4681-3	Doubler	16 Ea (2 ea)	150-Skid tubes	5075469
MS20470AD4-6	Rivet, Universal Head	712 Ea (89 ea)	150-Skid tubes	681x 5041165
				31x 5053658

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2963-125	8	122	0
150-Skid tubes	D4681-3	16	25	0
	MS20470AD4-6	712	2,669	0

Part Specifications

Specifications could not be found.

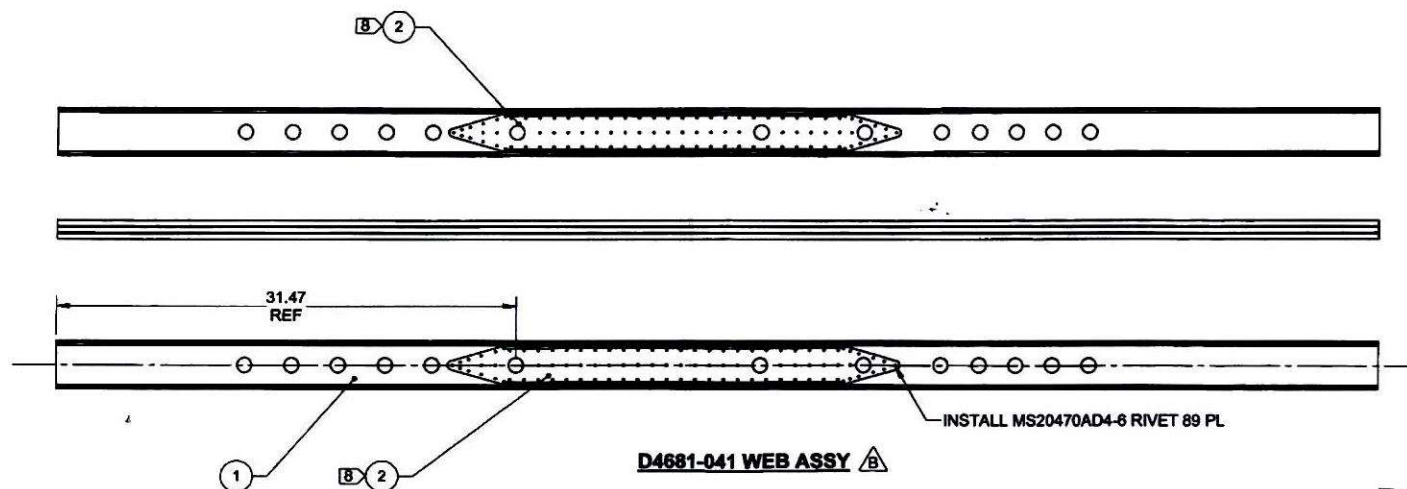
Plex 6/19/18 3:32 PM dart.white.jesse

**Container No: S084645****Part: D4681-041****Job No: 179497****Serial No/Batch: S084645****Revision: b****Inspector:****Exp Date:****Instructions:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/18

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4681-041	WEB ASSY
1	1	D4681-1	WEB
2	2	D4681-3	DOUBLER
3	89	MS20470AD4-6	RIVET, PAN HEAD



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4681-041" AND B/N PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 5.94 lbs
 - 8) SEAL FAYING SURFACES WITH PROSEAL P/S 890 B-1/2 (PRC)

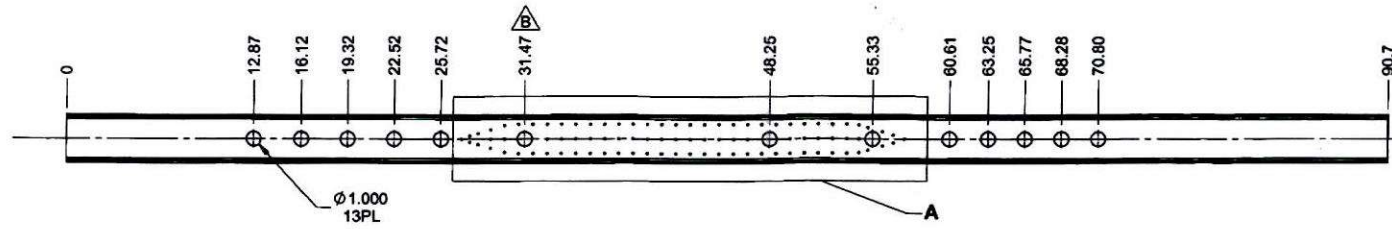
B	MS20470AD4-6 WAS MS20470AD4-7, ADDED DETAIL A ON SHEET 2. VARIOUS DIMENSIONAL CHANGES.	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	ALS		
MFG. APPR.	2/		
APPROVED	2/		
DE APPR.	2/	DRAWING NO. D4681 REV. B TITLE WEB ASSY SCALE NTS	
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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2013-12-13
WJ

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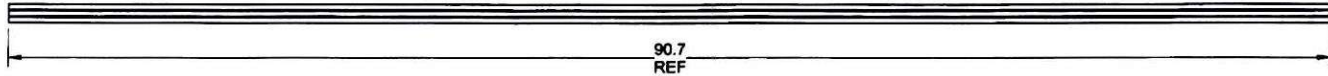
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D4681-1 WEB

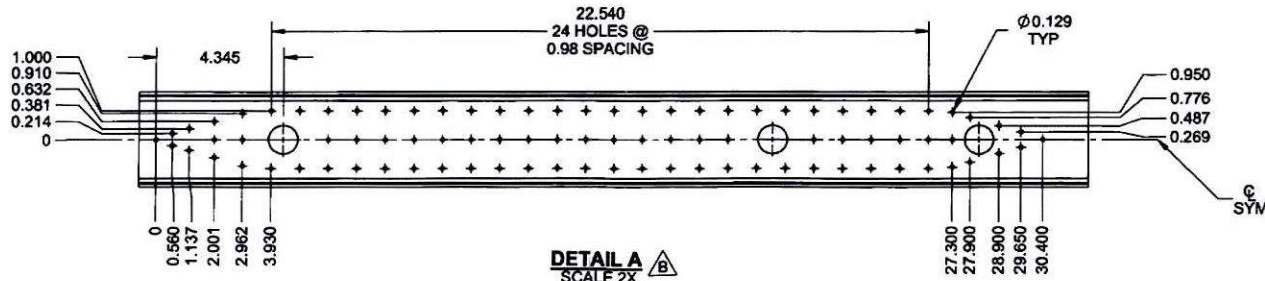
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B

B



DETAIL A
SCALE 2X

RELEASE
2013-11-13

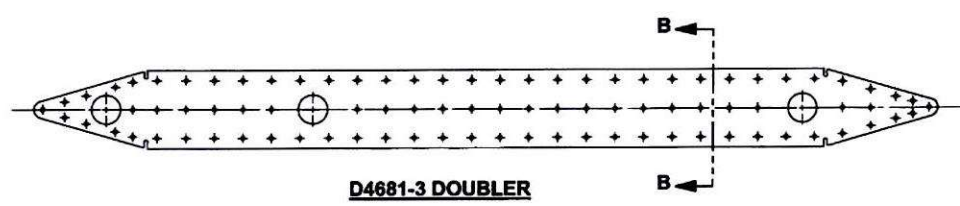
NOTES:

- 1) MATERIAL: MAKE FROM D2963-092 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 4.74 lbs

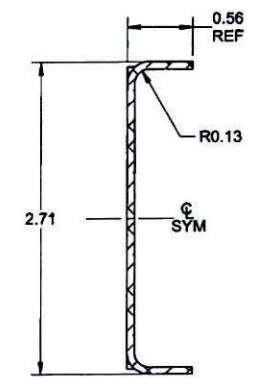
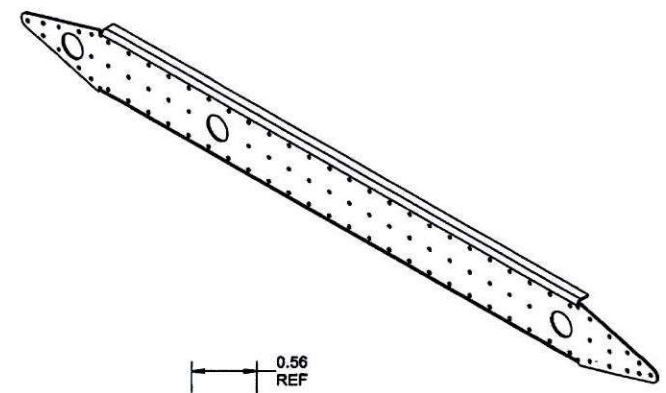
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MFG. APPR.	AP	D4681	SHEET 2 OF 4
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8 7 6 5 4 3 2 1



D4681-3 DOUBLER



SECTION B-B
SCALE 4X

RELEASED
2013-11-13
MP

NOTES:

- 1) MATERIAL: MAKE FROM D4681-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: .56 lbs

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MFG. APPR.	NS	D4681	SHEET 3 OF 4
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